

REPRINT

Work Order ID 151217

151217

Page 1

Thursday, September 29, 2016 2:19:26 PM

Item ID: D4011-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp, Short
 Start Date: 9/15/2016 Start Qty: 100.00 *100* Cust Item ID:
 Required Date: 9/23/2016 Req'd Qty: 100.00 *100* Customer:
 Reference:

Approvals: Process Plan: Em Date: 16/09/29 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4011	C								
100	PURCHASING	0.00							
100									
Waterjet	Memo	0.83							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.17							
Quality Control									

(105) _____ ac 16/09/30

(105) _____ ac 16/09/30

Thursday, September 29, 2016 2:19:26 PM

Page 2

NS1

Stop *NS2*

Customer:

Run Start *NR1*

Stop ***NR2***

NR2

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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105

OCT 03 2016

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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DAS
30
9-89

105

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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105

OCT 06 2016

151217

Thursday, September 29, 2016 2:19:26 PM

NS1

Stop ***NS2***

Customer:

Run Start *NR1*

Stop ***NR2***

NR2

**Insp.
Stamp**

6

9-89

OCT 07 2016

9-89

OCT 07 2016

Picklist Print

Thursday, September 29, 2016 2:19:38 PM

Page 1

Work Order ID: 151217

151217

Parent Item: D4011-1

D4011-1

Parent Item Name: Clamp, Short

Start Date: 9/15/2016

Required Date: 9/23/2016

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP RevA: New issue DD verified by:EC
11.05.19 MADE IN HOUSE DD verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	23.7000	0.07	7.368421			

M304S14GA

304SS sheet .080

on 10/09/30

Location

Loc Qty

Loc Code

MAT019

23.7

M129972

5.7

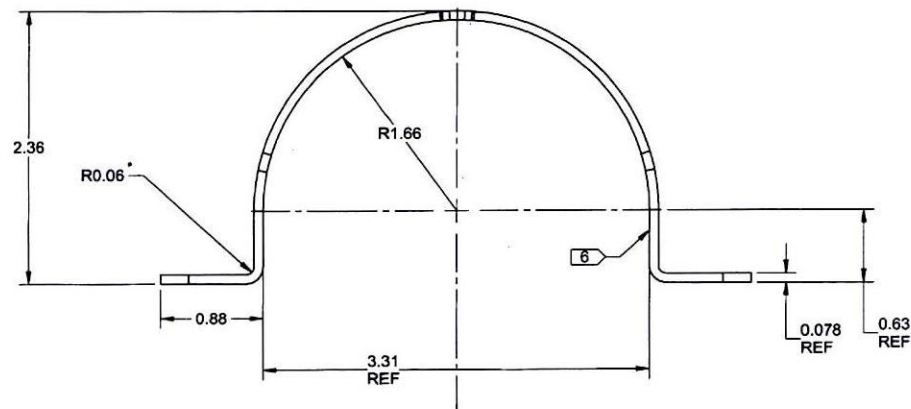
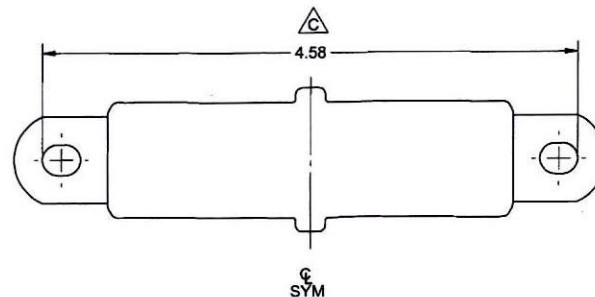
M135061

3.8

M135689

14.2

8.3



D4011-1 CLAMP, SHORT

RELEASED

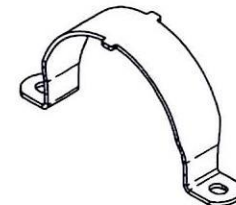
2015 MAR 26

4P EGN 15-532



NOTES:

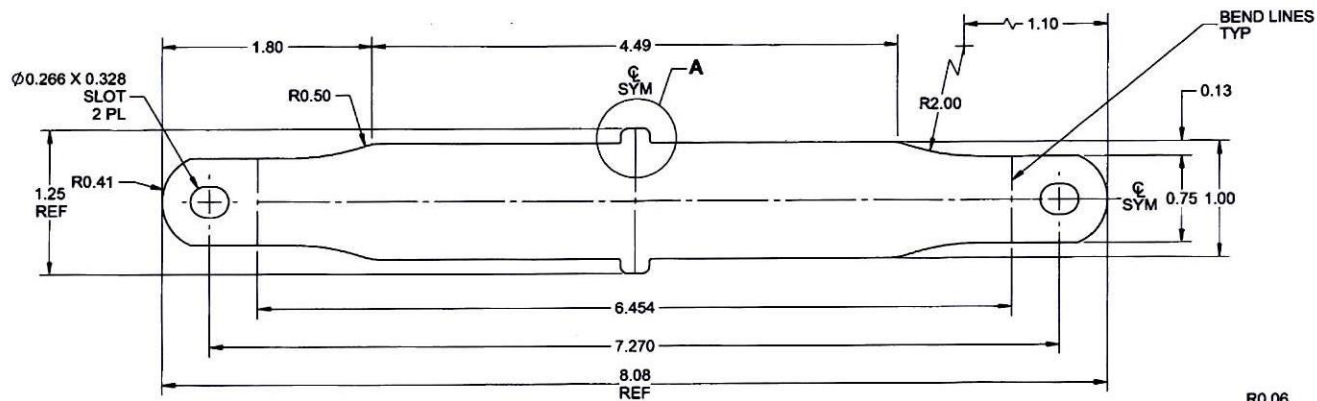
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-1" AND B/N PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.02 lbs



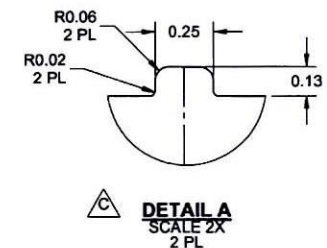
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151217

Em 16/09/29

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF		
	MFG. APPR.	DD		
APPROVED	APPROVED	HS	D4011 CLAMP	
	DE APPR.	DS		
	DATE	14.09.22		
REV.		DESCRIPTION	BY	DATE
C		ADD SLOT HOLES, ADD CUSHION RETENTION DETAILS TO -1/3-5 CLAMPS, REASON: PAR 14-331, NCR 14-3521, PAR 14-388, ZND5-1, A8-1, B6-2, B2-2, D4-3, A8-3, B6-4, B2-4, DS-5, A8-5, B6-6, B2-6, REVISE NOTE 6; ZN A8-2, A8-4, A8-6	VS	14.09.22
B		SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125; ADDED -.5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A		NEW ISSUE	MB	09.10.21
DESIGN		VS	DART AEROSPACE LTD	
DRAWN		VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		RF	DRAWING NO. D4011	
MFG. APPR.		DD	REV. C SHEET 1 OF 6	
APPROVED		HS	TITLE CLAMP	
DE APPR.		DS	SCALE NTS	
DATE		14.09.22	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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D4011-1F CLAMP, FLAT PATTERN SHORT



NOTES:

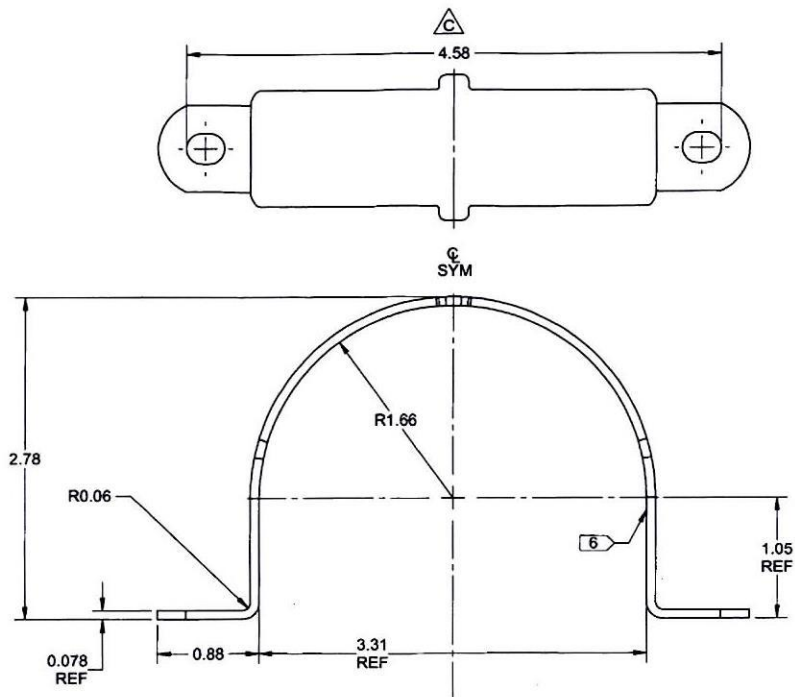
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) FOR UNDIMENSIONED DETAILS, REFER TO FLAT PATTERN CAD FILE D4011-1F-RevC.DXF

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2015 MAR 26

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DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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D4011-3 CLAMP, LONG

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2015 MAR 26 4P

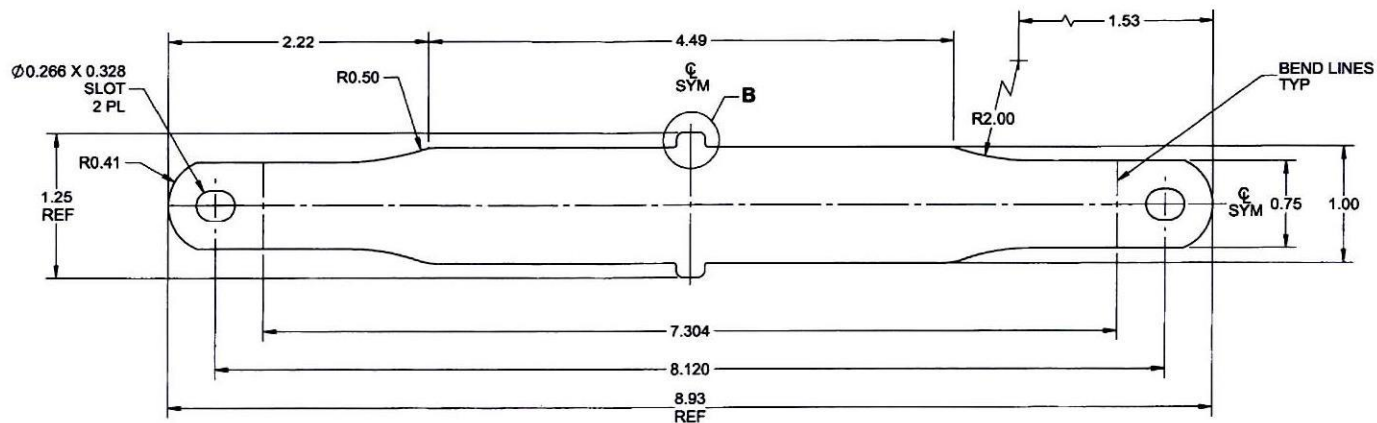


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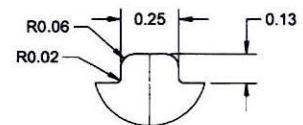
- 1) MATERIAL: MAKE FROM D4011-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-3" AND B/N PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.02 lbs

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DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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D4011-3F CLAMP FLAT PATTERN, LONG



DETAIL B
SCALE 2X
2 PL

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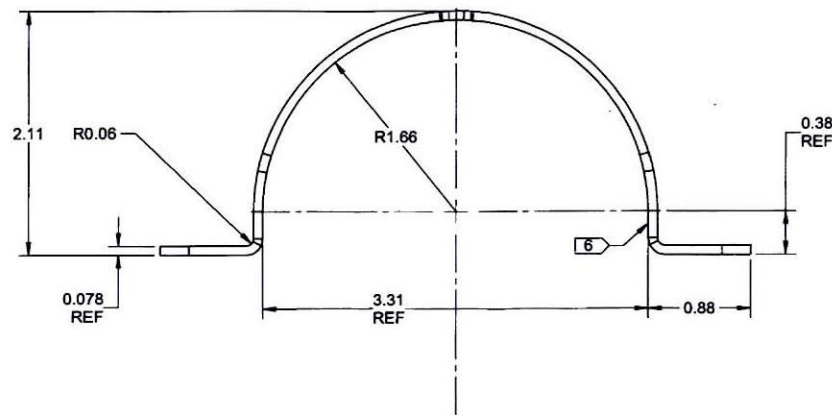
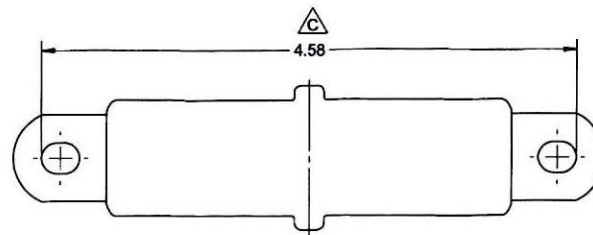
2015 MAR 26

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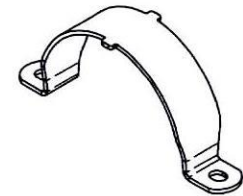
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) FOR UNDIMENSIONED DETAILS, REFER TO FLAT PATTERN CAD FILE D4011-3F-RevC.DXF

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DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 4 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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D4011-5 CLAMP, SHORT (OEM)



NOTES:

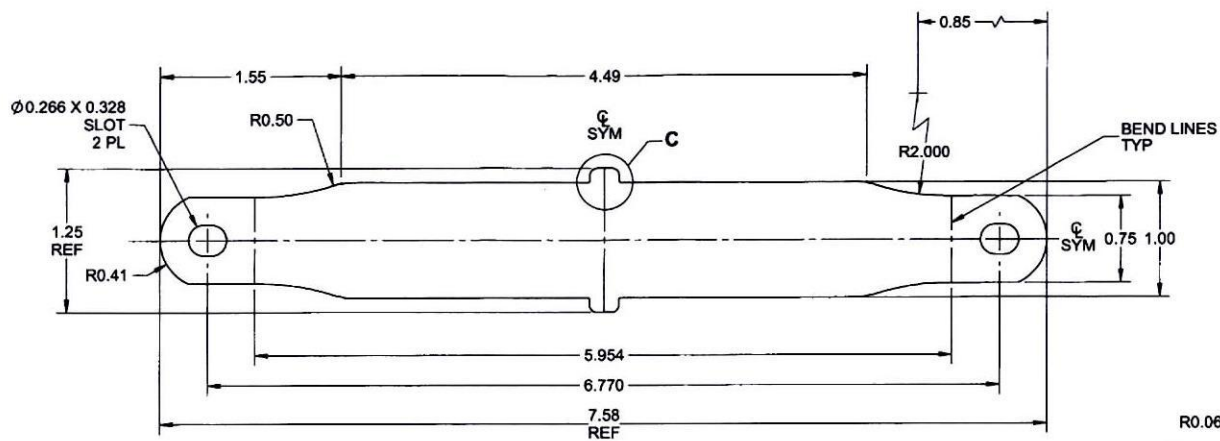
- 1) MATERIAL: MAKE FROM D4011-5F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-5" AND B/N PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.02 lbs

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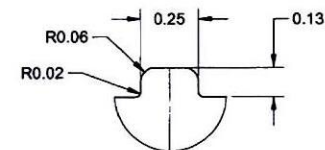
2015 MAR 26 *up*

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CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 5 OF 6
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D4011-5F CLAMP, FLAT PATTERN, SHORT (OEM)



DETAIL C
SCALE 2X

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2015 MAR 26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) FOR UNDIMENSIONED DETAILS, REFER TO FLAT PATTERN CAD FILE D4011-5F-RevC.DXF

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DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 6 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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